

Work Order ID 53470

November 6, 2009 8:38:41 AM



Page 1

Item ID: D3238-31

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 05/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date:

11-5

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3238	Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3238 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary ☐ ***Use cutting file D3238-21-23-25*****

6061 .020

11-18

11/11/18 *(24)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-18

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

27 Serials

locate

(24)

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Item ID: D3238-31

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Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 05/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>76</u>	0.00							
Packaging	Memo	0.00							
Packaging									

W 09/11/23

(124)

Ø

BF 09-11-23

(24)

19/11/23 (24)

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Item ID: D3238-31

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 05/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 13/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/24 J

MF
09-11-23

Picklist Print

November 6, 2009 8:38:45 AM

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Work Order ID: 53470



Parent Item: D3238-31RevC



Parent Item Name: Plate

Start Date: 05/11/2009

Required Date: 13/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.020		Purchased	No			100	sf	38.1700	0.2526	7		



18 9-11-10

6061-T6 Sheet .020

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

38.17

112442

38.17

112442

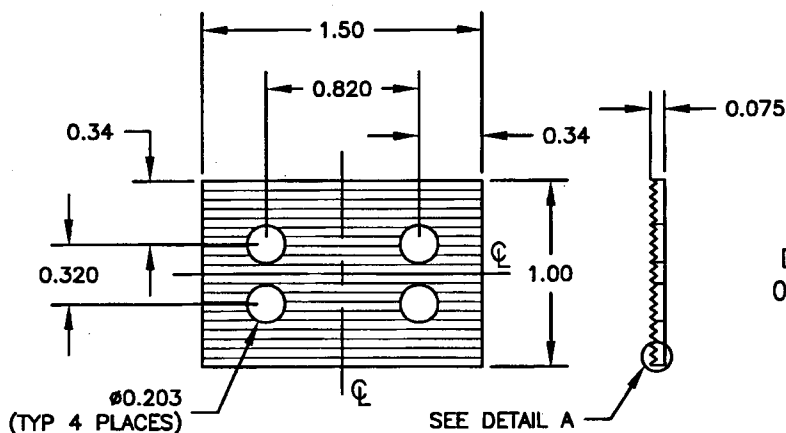
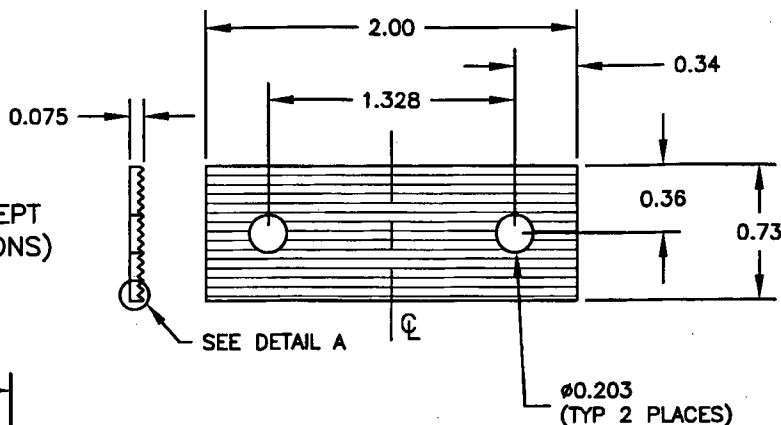
24

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

D3238-1 PLATE (SHOWN)D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**D3238-3 PLATE (SHOWN)**D3238-13 PLATE (SAME, EXCEPT SHOP COPY
0.020 THICK AND NO SERRATIONS)RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 53470
PA 09-11-5**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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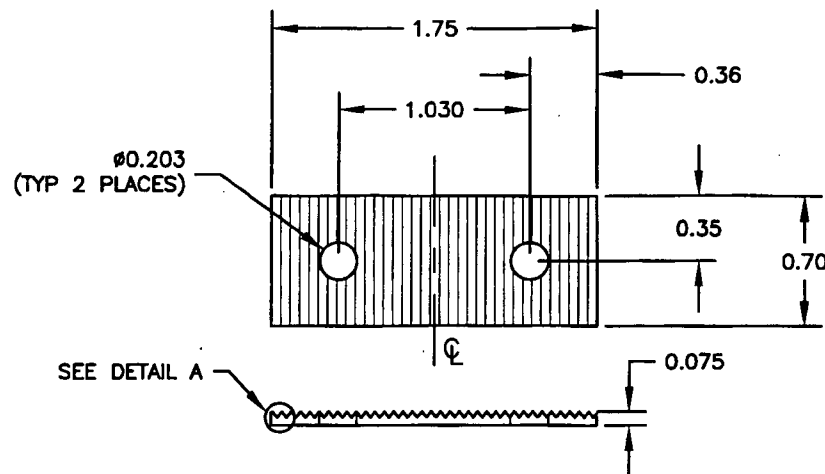
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DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1

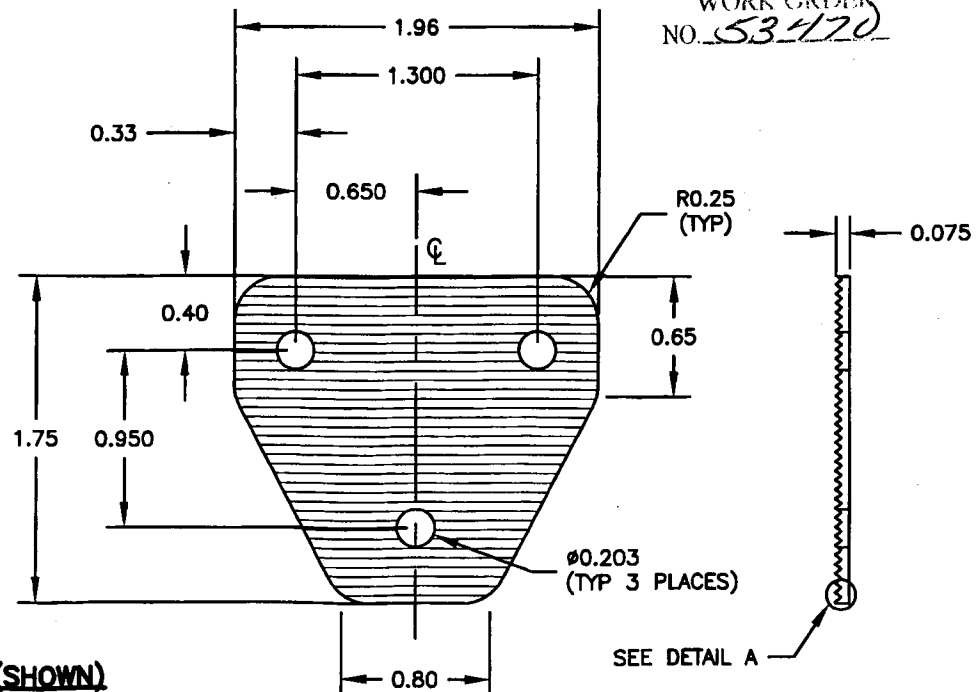
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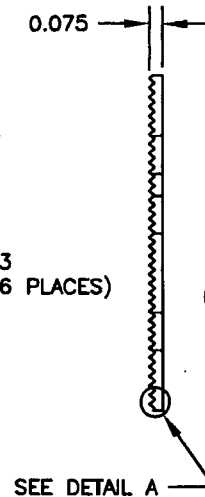
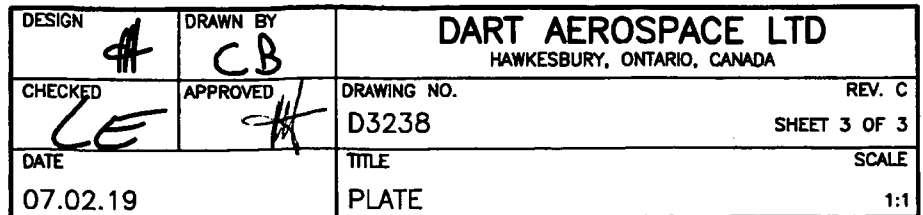
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D3238-21 PLATE (SHOWN)
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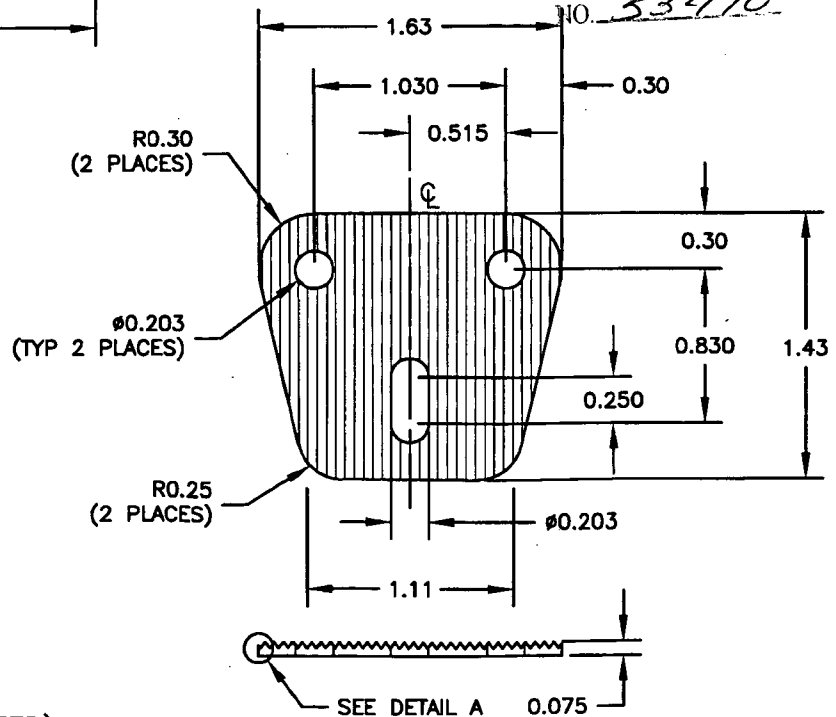


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WITH FINISHED
WORK ORDER

NO. 53470



RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1

D3238-35 PLATE (SAME, EXCEPT
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